

Date: Friday, 02/01/2009 8:33:57 AM
 User: Jean-Luc Menard

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PIVOT ARM
Job Number :	44347		
Estimate Number :	12771		
P.O. Number :		Part Number :	41232 200 002 005
This Issue :	02/01/2009 S.O. No. :	Drawing Number :	41232-200-002 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	02/01/2009 Type : MACHINED PARTS	Drawing Revision :	A
Previous Run :	43305	Material :	
Written By :	<i>JLM</i> 09-01-02	Due Date :	09/01/2009 Qty: 8 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A New Issue 07-03-05 JLM Est Rev:B Now on Doosan Lathe 08-05-13 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1250	2024-T3 Round Bar 1.250"
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Comment: Qty.: 0.3675 f(s)/Unit Total : 2.9400 f(s)
 2024-T3 Round Bar 1.250"
 Batch: *10110063*

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA745 Rev: *N/A* & Dwg 41232-200-002 Rev: *A*

2-Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting PURCHASING
 Issue P/O: *7908*
 Black Anodize as per Dwg 41232-200-005
 Ensure Certificate of Conformity is attached

C209/01/06

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT ARM

Job Number: 44347

Part Number: 41232 200 002 005

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

129/01/14 (8)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

509/01/14 (X8)

8.0	MS21209F410	heli-coil
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
HeliCoil 1/4"-28NF(RED)
Batch: 108085

FF 09/01/28

(8)

9.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Install Helicoil as per Dwg 41232-200-005.

FF 09/01/28

(8)

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

502/01/28 (X8)

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 364

9/1/29

SO

(8x)

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/02 (X8)

Job Completion



JUD 09.01.29

(8)

DART AEROSPACE LTD		Work Order:	44347
Description: Pivot Arm		Part Number:	41232-200-002-005
Inspection Dwg: 41232-200-002		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

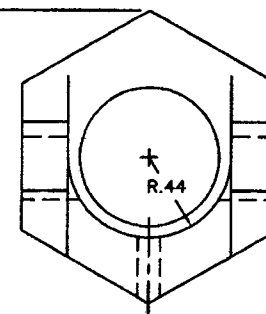
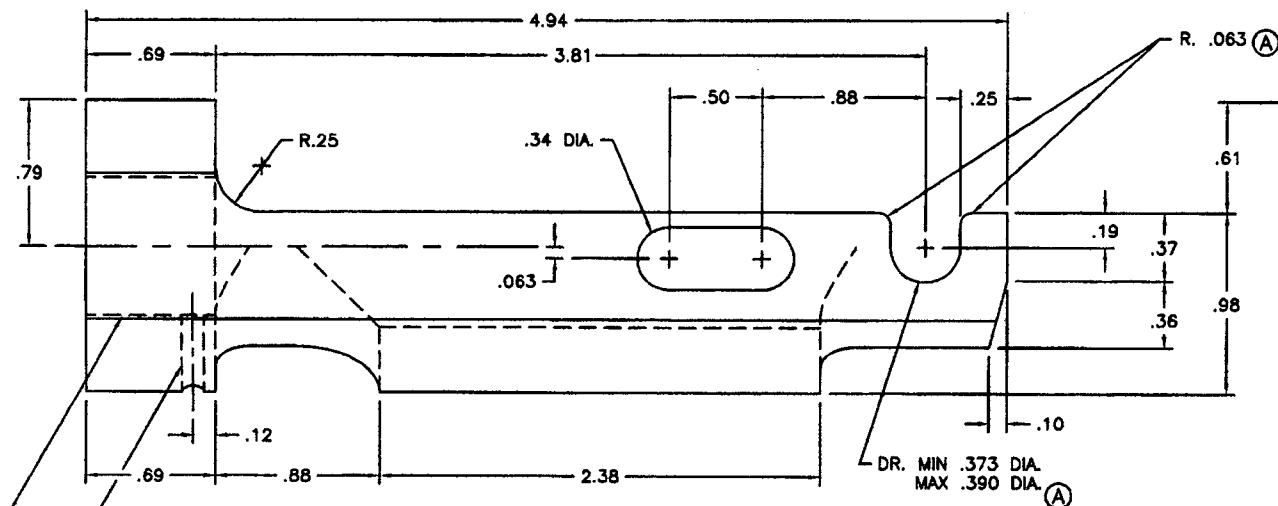
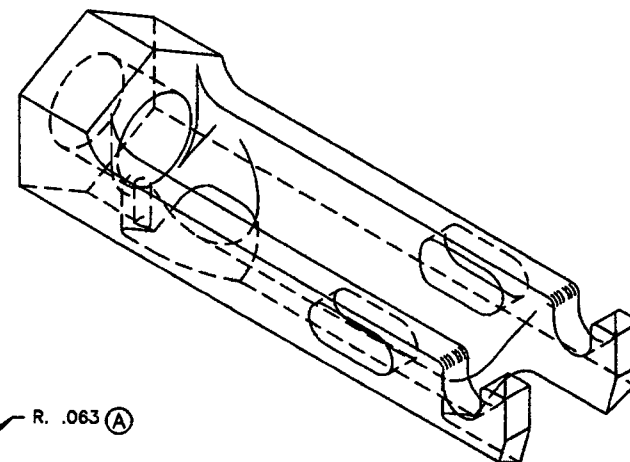
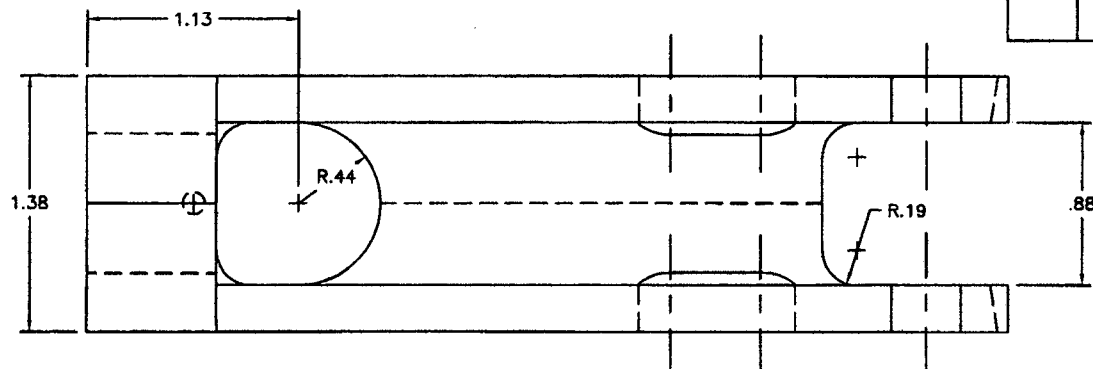
☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	.38				
0.25	+/-0.030	.25				
0.38	+/-0.030	.38				
Ø0.375	+/-0.010	.375				
Ø1.00	+/-0.030	1.00				
3.56	+/-0.030	3.55				
1.31	+/-0.030	1.31				
0.63	+/-0.030	.63				
0.50	+/-0.030	.50				
0.38	+/-0.030	.38				
0.31	+/-0.030	.31				
0.19	+/-0.030	.19				
R0.12	+/-0.030	R.12				
Ø0.25	+/-0.030	.25				
1/4-28 HC	N/A	1/4-28 HC				

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/02/02	Date:	09/01/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.03	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.		
MINOR CHANGE - FAR 21.95			CHECK	D. MURPHY	2/17/03



DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D (A))

3/4"-20 THD.

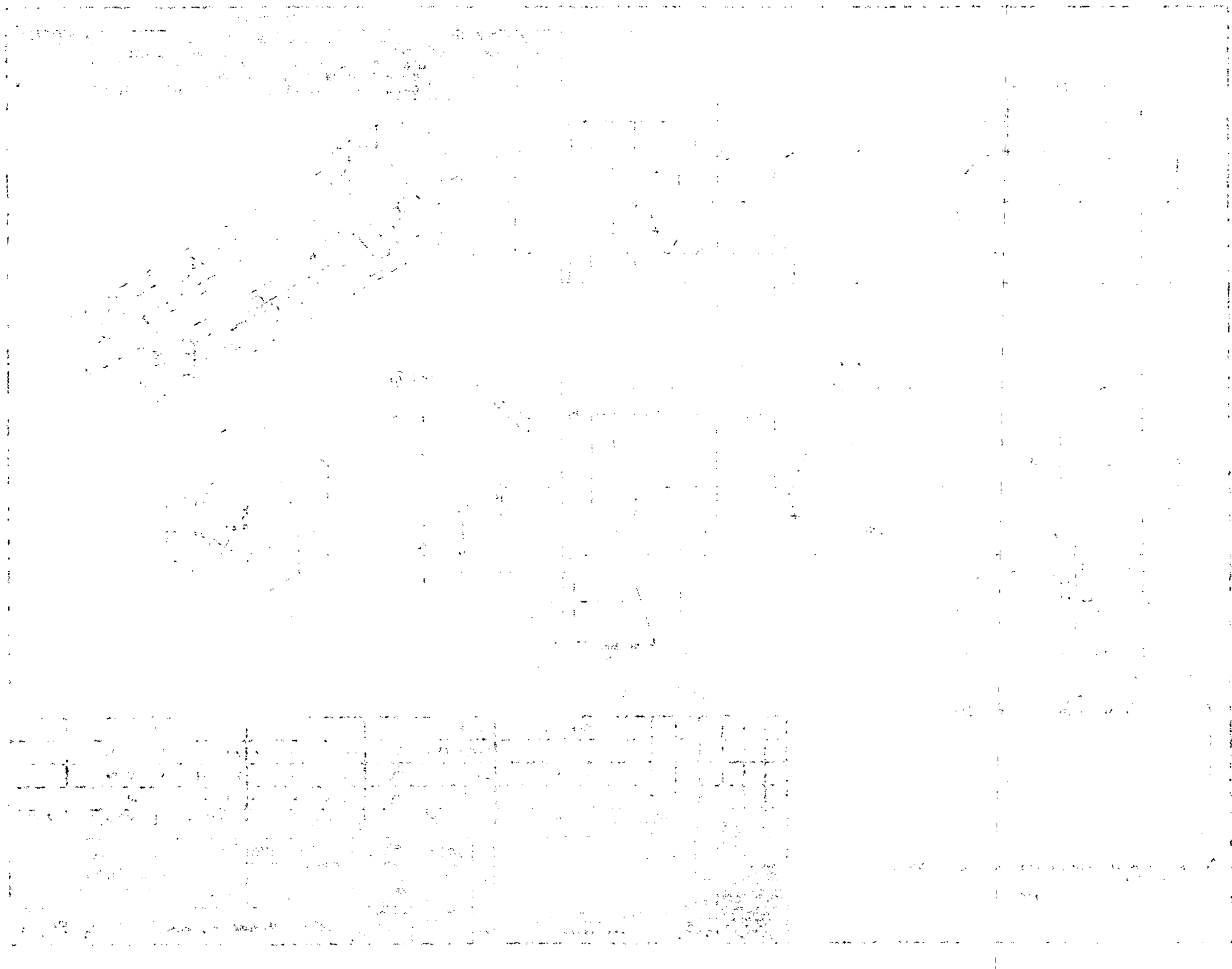
-001 TUBE

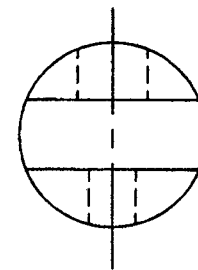
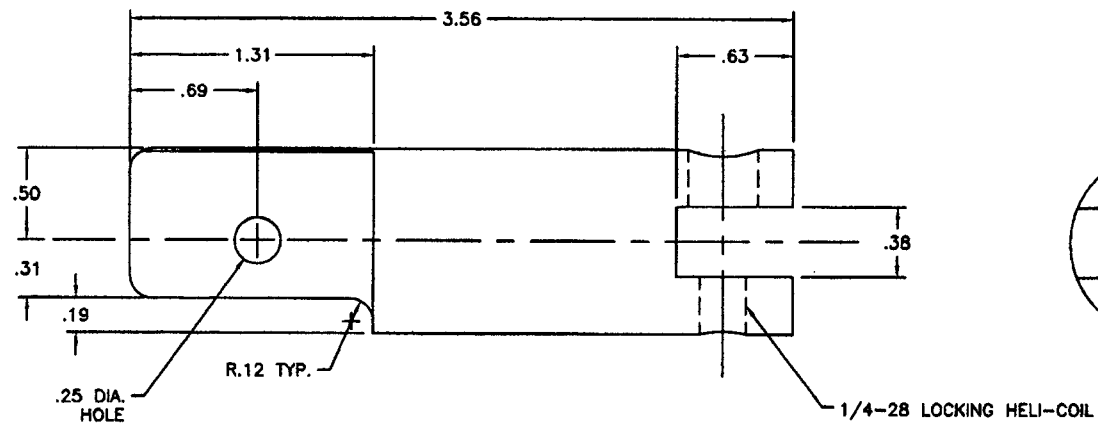
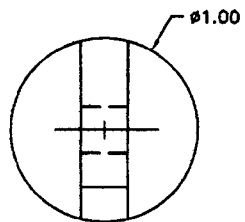
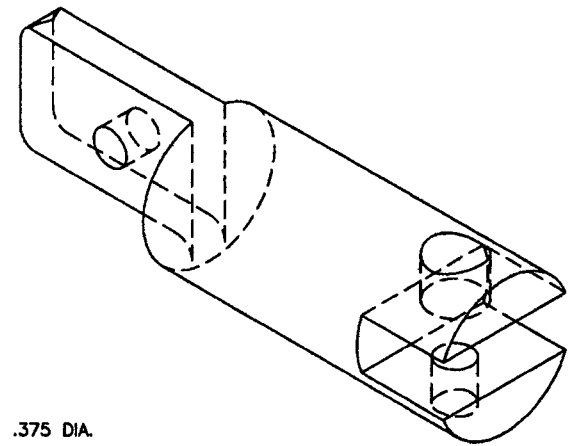
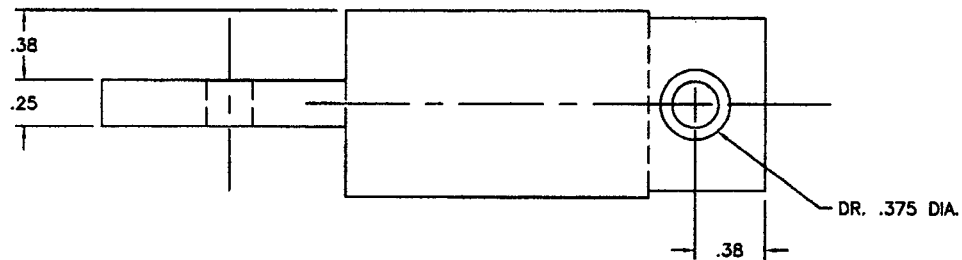
44347

1	MS21209F4-15	INSERT				
	-005	PIVOT ARM (A)	1.00 DIA. x 3.56	2024-T4, T351 ALUM.		
	-003	LATCH (A)	1.11 x 3.50	2024-T4, T351 ALUM.		
	-001	TUBE (A)	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.		
	-005	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC
NO. REQ'D PER ASSY						
LIST OF MATERIAL						
PROPRIETARY RIGHTS NOTICE			DFTSMAN D. NELSON 2/18/02			
UNLESS OTHERWISE SPECIFIED X.1			CHECK D. MURPHY 2/18/02			
XX.1.03			STRESS			
XX.1.010			PROL. DWGR.			
ANGLES 2.1/2"			HEAT TREAT			
FINISH (A)			STEP ACTUATOR COMPONENTS			
2 41232-200-001			DNG. SIZE C SCALE 2:1			
NEXT ASSEMBLY			Eva Aviation, Inc.			
			DNG. NO. 41232-200-002			
			SHT 1 OF 3			
			REV. A			

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2 DYED BLACK.

NOTE:





44347

-005 PIVOT ARM

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Era Aviation, Inc.

TITLE

STEP ACTUATOR COMPONENTS

SIZE

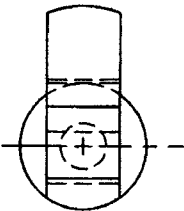
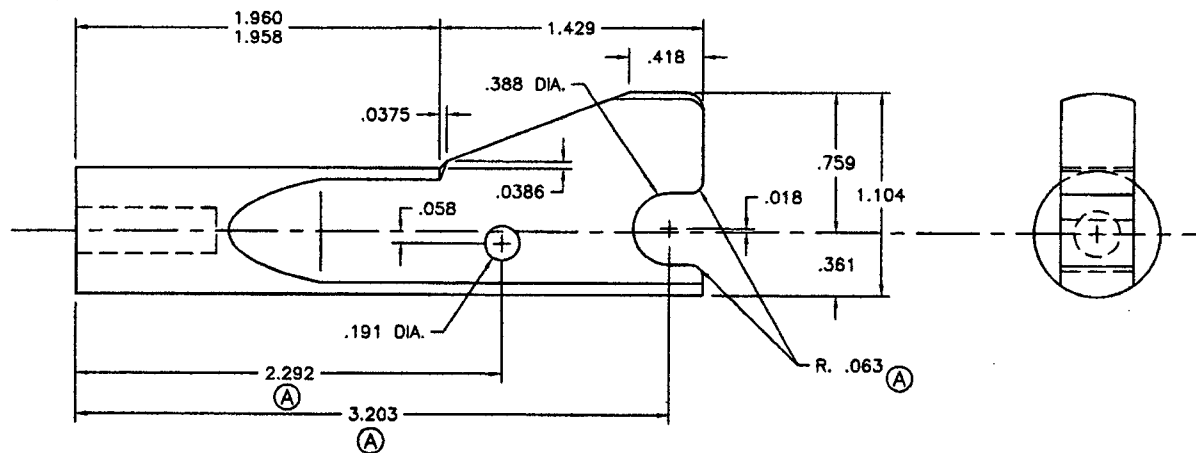
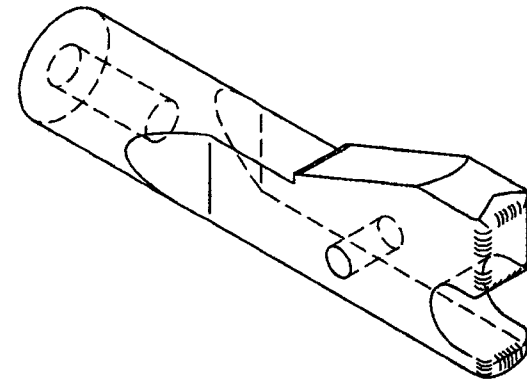
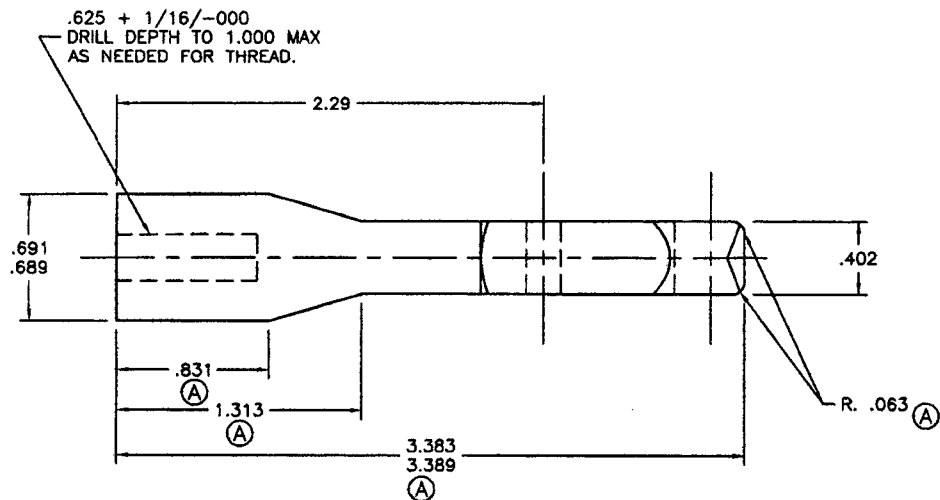
C

DATA NO.

41232-200-002
SHT 3 OF 3

REV.

A



44347

-003 LATCH

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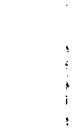
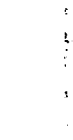
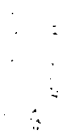
Era Aviation, Inc.

TITLE STEP ACTUATOR COMPONENTS

SIZE C

DWG. NO. 41232-200-002
SHT 2 OF 3

REV. A



DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

Length

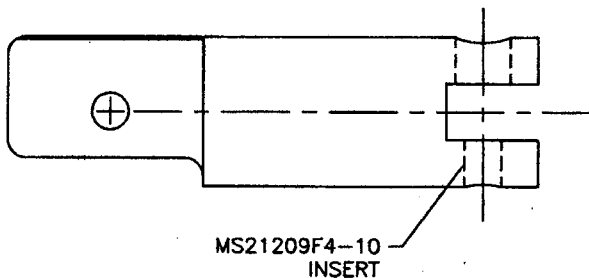
IS

1	MS21209F4-10	INSERT
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WAS

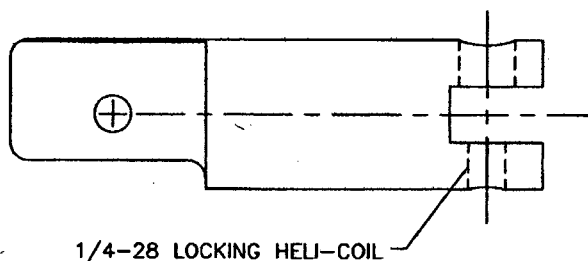
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

71433

12-Jan-2009

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

NO. DE COMMANDE:

PURCHASE ORDER/

7908



ITEM	QTY	UNIT	DESCRIPTION	PROCESS & TREATMENT
1	8	8	41232-200-002-005 B44347	BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

S
09/01/14

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager